

Work Order ID 148386

Tuesday, June 28, 2016 10:09:58 AM

148386

Page 1

Item ID: D412-761-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Full Vertical Reference Door Modification (Wide Armrest)
 Start Date: 6/24/2016 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 7/13/2016 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: DAS 21 Date: JUL 05 2016 Tooling: _____ Date: _____
 QC: 9-89 Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr							DAS	
IIN D412-761	F	DAS 6 9-89	Label	0102 1 1 700				21 9-89	16-07-12
100	Document Control	0.00						DAS 27 9-89	
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP D412-761-041 CHG003								
110	Pick Kit	0.00						DAS 6 9-89	
110									
Packaging	Memo	0.00							0102 1 1 700
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00						DAS 27 9-89	
120									
QC	Memo	0.00							
Quality Control									

JUL 13 2016

JUL 13 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																						
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																						
Large Fab ☐	Composite ☐	Supplier ☐																							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐				Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐				Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐				Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐											
		OTHER : _____																							

Work Order ID 148386***148386***

Page 2

Tuesday, June 28, 2016 10:09:58 AM

Item ID: D412-761-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Full Vertical Reference Door Modification (Wide Armrest)

Start Date: 6/24/2016 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 7/13/2016 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-761-041								
	Location: _____								
	PPP Rev: _____								
		<i>sold</i>							
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.02							
Quality Control									

JUL 13 2016

DAS
21
9-89

JUL 13 2016

SA 7/13/16

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	
		OTHER : ☐							

Picklist Print

Tuesday, June 28, 2016 10:09:58 AM

Page 1

Work Order ID: 148386

148386

Parent Item: D412-761-041

D412-761-041

Parent Item Name: Full Vertical Reference Door Modification (Wide Armrest)

Start Date: 6/24/2016

Required Date: 7/13/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 09-01-13 rev.C as per dwg DD verified by:EC IPP Rev:B as per ECN10-573 DD 10.05.18 verf:EC IPP Rev:C 13.01.15 as per ECN13-511 DD Verf:JLM IPP Rev:D 16.06.21 PER IIN REV.F DD Verf:JLM IPP REV:E 16.06.24 PER CH003 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D412-761-053		Manufactured	No				Each	1.0000		1			

~~*D412-761-053*~~

Door Mounted Instrument Panel, LH

NIA 6/16/11

Location	Loc Qty	Loc Code
FG020	1	
116704	1	

D412-761-045		Manufactured	No			110	Each	0.0000	1	1			DAS 6 9-89
--------------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	------------------

D412-761-045

Bubble Window

D412-761-047		Manufactured	No			110	Each	3.0000	1	1			
--------------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

D412-761-047

Instrument Panel

DAS
27
9-89

Location	Loc Qty	Loc Code
FG020	3	
146048	1	
146948	2	

D412-761-049		Manufactured	No			110	Each	0.0000	1	1			DAS 6 9-89
--------------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	------------------

D412-761-049

Armrest

DAS
27
9-89

JUL 11 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Chris Provencal

From: Shirley Hay
Sent: Monday, July 11, 2016 1:39 PM
To: Chris Provencal
Subject: FW: d412-761-041

fyi

Thank you

Have a great day!

SHIRLEY

From: David Shepherd
Sent: July 06, 2016 5:10 PM
To: Linda Lacelle <llacelle@dartaero.com>; Harvey Siemens <hsiemens@dartaero.com>; Arkam Kindeel <akindeel@dartaero.com>
Cc: Shirley Hay <shay@dartaero.com>; Marc Bellavance <mbellavance@dartaero.com>; Lori Morris <lmorris@dartaero.com>
Subject: RE: d412-761-041

Linda,

Sorry for the slow reply. I had Arkam incorporate DSI 9681 into IIN-D412-761 Rev F, which meant adding the optional D412-761-053 kit. What I didn't notice is that he added this optional kit to the BOM for D412-761-041/-041A, which is NOT correct. The D412-761-053 kit should be removed from the BOM for D412-761-041/-041A. The customer doesn't need to receive 2 instrument panels with his door. Sorry for the confusion.

Marc,

Can you please create a PAR/NCR/CAR to request an update to IIN-D412-761 to remove the D412-761-053 kit from D412-761-041/-041A.

Regards,
David

From: Linda Lacelle
Sent: July-06-16 1:12 PM
To: David Shepherd <dshepherd@dartaero.com>; Harvey Siemens <hsiemens@dartaero.com>; Arkam Kindeel <akindeel@dartaero.com>
Cc: Shirley Hay <shay@dartaero.com>; Marc Bellavance <mbellavance@dartaero.com>; Lori Morris <lmorris@dartaero.com>
Subject: RE: d412-761-041

Any news on this one please?

148386

Tuesday, June 28, 2016 10:09:58 AM

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Item Name: Full Vertical Reference Door Modification (Wide Armrest)

Start Date: 6/24/2016 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 7/13/2016 **Req'd Qty:** 1.00 ***1***

Customer:

Reference:

Approvals:

Process Plan:	DAS	Date:	JUL 05 2016	Tooling:		Date:	
	ZT						
QC:	S-S9	Date:		SPC (Y/N):		Date:	

Run Start *NR1*

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
D-46 *100*	IIN D412-761 F	9-89	Label					DAS 21 JUL 12 2016 9-89	
100	Document Control	0.00							
	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP D412-761-041 CHG003								
Packaging *110*	Pick Kit	0.00							
Packaging	Memo	0.00						JUL 11 2016	
Packaging									
QC *120*	QC4- 100% Inspect kits for completeness	0.00							
Quality Control	Memo	0.00							

5.0 PARTS LIST, MODIFIED FULL VERTICAL REFERENCE DOOR KITS

QTY -011	QTY -011A	QTY -041	QTY -041A	QTY -043	QTY -045	QTY -047	QTY -049	QTY -051	QTY -053	QTY -141	PART NUMBER	DESCRIPTION
X											D412-761-011	FULL VERTICAL REFERENCE DOOR, LH
	X										D412-761-011A	FULL VERTICAL REFERENCE DOOR, LH
1		X									D412-761-041	FULL VERTICAL REFERENCE DOOR KIT, LH
	1		X								D412-761-041A	FULL VERTICAL REFERENCE DOOR KIT, LH
				X	1						D412-761-043	MODIFIED LATCH MECHANISM KIT, LH
		1	1		X						D412-761-045	LARGE BUBBLE WINDOW KIT, LH
		1	1			X					D412-761-047	DOOR MOUNTED INSTRUMENT PANEL KIT, LH
		1	1				X				D412-761-049	ARMREST KIT, LH
			1					X			D412-761-051	ARMREST KIT, LH
		1	1						X		D412-761-053	DOOR MOUNTED INSTRUMENT PANEL KIT, LH
1	1									X	D412-761-141	VENT KIT
1	1										204-030-853-125 OR 204-030-853-137 OR 204-030-853-155 OR 204-030-853-153	BELL 204, 205, 210, 412 OEM DOOR

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Revision: F
Date: 16.05.26

REFERENCE ONLY

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IIN-D412-761

Page 11 of 15

6.0 PARTS LIST, FULL VERTICAL REFERENCE DOOR MOD KITS

QTY -041	QTY -041A	QTY -043	QTY -045	QTY -047	QTY -049	QTY -051	QTY -053	QTY -141	PART NUMBER	DESCRIPTION
									D412-761-011	FULL VERTICAL REFERENCE DOOR, LH
									D412-761-011A	FULL VERTICAL REFERENCE DOOR, LH
X									D412-761-041	FULL VERTICAL REFERENCE DOOR KIT, LH
	X								D412-761-041A	FULL VERTICAL REFERENCE DOOR KIT, LH
		X	1						D412-761-043	MODIFIED LATCH MECHANISM KIT, LH
1	1		X						D412-761-045	LARGE BUBBLE WINDOW KIT, LH
1	1			X					D412-761-047	DOOR MOUNTED INSTRUMENT PANEL KIT, LH
1					X				D412-761-049	ARMREST KIT, LH
	1					X			D412-761-051	ARMREST KIT, LH
1	1						X		D412-761-053	DOOR MOUNTED INSTRUMENT PANEL KIT, LH
								X	D412-761-141	VENT KIT
		1							D3589-041	LATCH ASSEMBLY
		1							D3589-047	FORWARD GUIDE
		1							D3589-049	AFT GUIDE
		2							MS16997-24	SCREW
		2							MS21042L06	NUT
		2							NAS1149DN632J	WASHER (OR AN960JD6L)
			1	1					D3676-1	LARGE BUBBLE WINDOW
			1						D3678-1	PLACARD
			1						D3678-3	PLACARD
			1						D3678-5	PLACARD
			1						D3700-1	INBOARD WINDOW DOUBLER
			1						D3700-3	OUTBOARD WINDOW DOUBLER
			1						D3701-1	FLOOR DOUBLER
			1						D3702-1	FORWARD DOUBLER
			1						D3703-1	AFT DOUBLER
			1						D3703-3	AFT CORNER DOUBLER
			1						D3703-5	AFT CAP
			1						D3704-1	ESCUTCHEON
			1						D3704-3	ESCUTCHEON
			1						D3708-1	ANGLE
			1						D3708-3	ANGLE
			1						D3709-1	ANGLE
			1						D3709-3	ANGLE
			1						D3802-1-135	SEAL
			1						DT9458	CUTTING TEMPLATE
		26							AN3-7A	BOLT
		26							MS21042L3	NUT
		1							MS24694-C5	SCREW (OR MS24694-S5)
		1							MS24694-C13	SCREW (OR MS24694-S13)
		1							NAS43DD3-24	SPACER
		52							NAS1149D0363J	WASHER (OR AN960JD10)

(CONTINUED ON PAGE 12)

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Revision: F
Date: 16.05.26